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**Han**

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(54) **SELF-ALIGNING MANUAL DIE SET FOR PRESSING EXPLOSIVE POWDER INTO PELLETS**

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(\*) **Notice:** Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

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(57) **ABSTRACT**

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(58) **Field of Search** ..... **264/3.4; 425/78, 425/DIG. 15, 412**

A manual die set for pressing explosive powder into pellets includes a ram, the ram having a head, a large diameter portion, a tapered portion, a small diameter portion and a pressing portion; a die defining an opening therethrough for receiving the ram, the opening including a large diameter portion, a tapered portion and a small diameter portion, the large diameter portion of the opening having a diameter less than or equal to about 0.002 inches larger than a diameter of the large diameter portion of the ram; a baseplate disposed in a bottom of the opening in the die; and a die holder for supporting the die and the baseplate when the manual die set is in a pressing configuration; wherein vertical alignment of the ram is maintained by insertion of the large diameter portion of the ram in the large diameter portion of the opening in the die.

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**13 Claims, 3 Drawing Sheets**

